



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4785-041
Job Sheet 168157



Part No: D4785-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, LH/RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/10/17

Job Tracking No:

Due Date: 12/27/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV B SHEETS 1,2,3,4 IPP REV:A 13.03.14 NEW ISSUE DD VERF:JLM IPP REV:B 13.06.17 as per dwg rev.pb1 DD VERF:JLM IPP REV:C 13.07.04 revise bom per dwg rev.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/25/17	12/25/17	0.00	0.00	Start Up Large Fab2		DC 2018-01-11
100	Large Fab	1 pcs	12/26/17	12/26/17	0.00	25.00	Large Fab 1		CR 18-1-11
110	QC	1 pcs	12/26/17	12/26/17	0.00	0.00	QC9		PD 18-01-15
120	QC	1 pcs	12/26/17	12/26/17	0.00	0.00	QC5		PD 18-01-15
125	HandFinish	1 pcs	12/26/17	12/26/17	0.00	0.52	HandFinish2		BR 18-01-16
130	Powdercoat	1 pcs	12/26/17	12/26/17	0.00	0.84	Powdercoat2		BR 18-01-16
140	QC	1 pcs	12/26/17	12/26/17	0.00	0.00	QC3		SL 18-1-16
150	HandFinish	1 pcs	12/27/17	12/27/17	0.00	0.52	HandFinish4	Sub	SL 18-1-16
160	QC	1 pcs	12/27/17	12/27/17	0.00	0.00	QC5		SL 18-1-16
170	Packaging	1 pcs	12/27/17	12/27/17	0.00	0.00	Packaging3		SL 18-1-16
180	QC21-SA	1 Ea	12/27/17	12/27/17	0.00	0.00	QC21		SL 18-1-16

Part Op 100 - 1- Use DT9610A to assemble contour ribs and the (2) D3916-5 ribs , weld as per dwg D4785 ***ENSURE BOTTOM Descriptions: OF BASE RIB ARE STRAIGHT*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D4785 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends ***USE DT10158 WITH SHIM WHEN WELDING BOTTOM OF RIB D4785-115*** 3- weld hinge (3) and Mounting brackets as per dwg D4785

110 - ***ENSURE BOTTOM OF BASE RIB ARE STRAIGHT*** Use DT10160 jig to ensure D4785-115 holes are align after welding

120 - ***ENSURE BOTTOM OF BASE RIB ARE STRAIGHT***

130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat

150 - Pick kit and assemble

M 138467. START: 11:00 O.V.T. 875° FINISH: 11:15.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581-5005842	2	103	0	0
	D3913-1	1	12	0	0
	D3913-3	1	15	0	0
	D3913-9	1	6	0	0
	D3916-5	2	12	0	0
	D4016-1	3	1	0	0
	D4017-7	3	49	0	0
	D4020-11	2	18	0	0
	D4021-5	2	18	0	0
	D4034-041	1	6	0	0
	D4034-043	1	6	0	0
	D4785-1	2	2	0	0
	D4785-115	4	4	0	0

	D4785-117	5014362	2	2	0	0
	D4785-3		2	5	0	0
	D4785-5	16455458	3	9	0	0
	D4793-1		3	10	0	0
	D4793-3	5007972	1	7	0	0
	M304EX0.75-16F	5012100	33	515	0	0
	AN3-10A	1864357	6	244	0	0
	D2931	1864357	2	236	0	0
	D4672-1	5005866	2	51	0	0
	MS20600-AD4W3	5017431	2	277	0	0
	MS21042L3	5016501	6	1,328	0	0
	NAS1149DN832J	137587-15	2	1,712	0	0
	NAS1149F0332P	5020603	12	2,740	0	0
Part Specifications						
Specifications could not be found.						

Plex 11/10/17 10:22 AM dart.poulin.mario

DART
AEROSPACE
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Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Long Basket Base Assembly, LH/RH

PART NO: D4785-041
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 01/11/18
Job No: 168157